

SPLIT

23

Date: Wednesday, 5/16/2007 1:40:46 PM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 32405  
Estimate Number : 10791  
P.O. Number : N/A  
This Issue : 5/16/2007 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : 31930  
Drawing Name : FLOAT WEB  
Part Number : D3282041  
Drawing Number : D3282 REV C  
Project Number : N/A  
Drawing Revision : C  
Material : N/A  
Due Date : 6/3/2007 Qty: 10 Um Each  
Written By :  
Checked & Approved By : 07.05.16  
Comment : Est Rev B 05.09.23 Procedure change KJ/JLM

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

10 D2792130 EXTRUSION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2792-130 Extrusion B24230

Identify as D3282-1

7-5-23

20 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

7-5-23

30 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

07/07/19

40 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/07/19

50 QC8 SECOND CHECK



Comment: SECOND CHECK

07/07/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:40:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 32405

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

R 7-7-20

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pm 07-07-2000

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

B32477 @

R 7-7-20

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total: 570.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M10085457

R 7-7-20

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282 Apply LPS-3 between doublers and web  
A/RN/LPS-3 M129929

R 7-7-20

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ep 07/07/23 (X)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

46 7-7-23

JP



Date: Wednesday, 5/16/2007 1:40:48 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 32405

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

07/14/07

Job Completion



U 8-07-24

DART AEROSPACE LTD		Work Order:	32403
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282 Rev: C		Page 1 of 1	

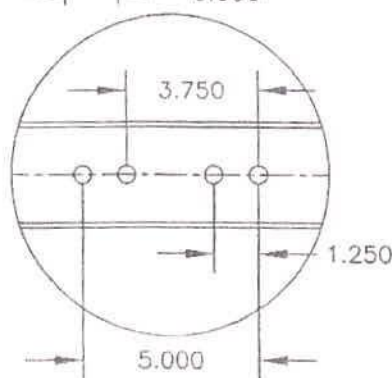
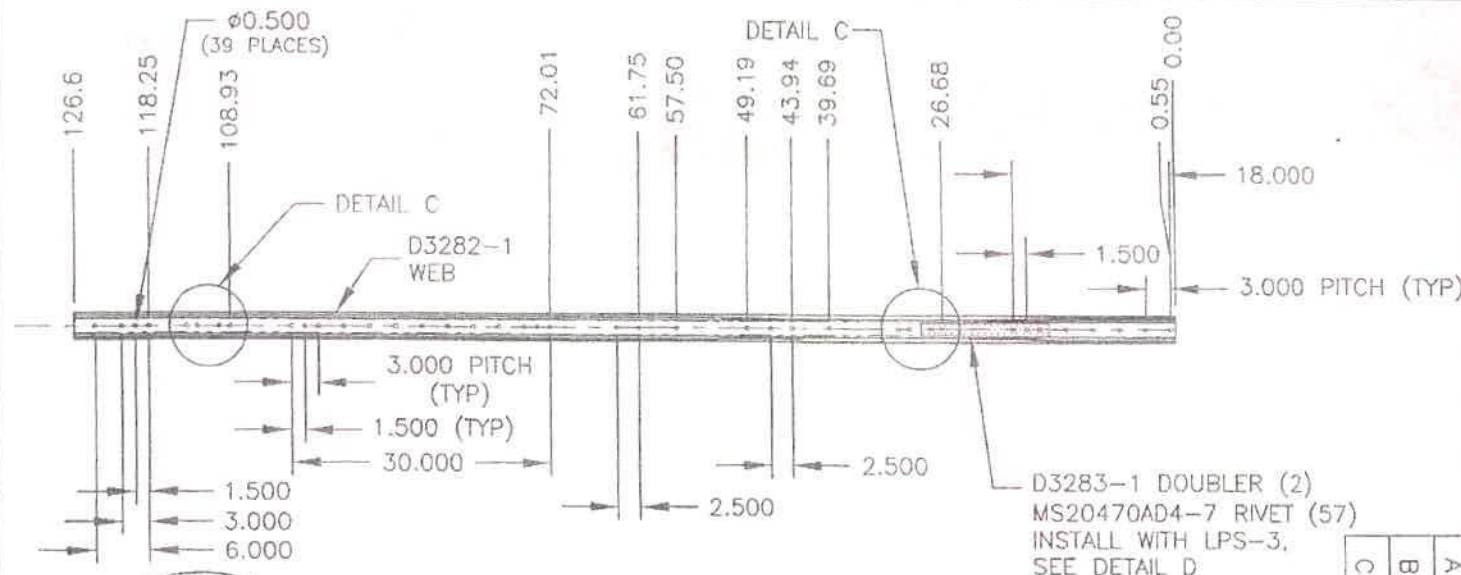
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

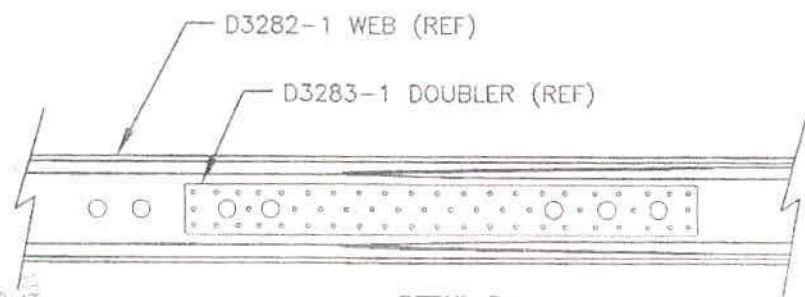
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.53	✓			
1.500	+/-0.010	1.500	✓			
3.000	+/-0.010	3.000	✓			
6.000	+/-0.010	6.000	✓			
1.250	+/-0.010	1.250	✓			
30.000	+/-0.010	30.000	✓			
1.500	+/-0.010	1.500	✓			
72.01	+/-0.030	72.00	✓			
61.75	+/-0.030	61.75	✓			
57.50	+/-0.030	57.5	✓			
49.19	+/-0.030	49.19	✓			
43.94	+/-0.030	43.94	✓			
39.69	+/-0.030	39.69	✓			
26.68	+/-0.030	26.68	✓			
0.55	+/-0.030	.55	✓			
1.970	+/-0.010	1.970	✓			
2.38	+/-0.030	2.38	✓			
0.05	+/-0.030	.05	✓			

Measured by: 569m	Audited by: J.L. SA	Prototype Approval:	N/A	
Date: 07.05.21	Date: 07/05/21	Date:	N/A	
Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	SA

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.		REV. C
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D3282	SHEET 1 OF 2
DATE	05.08.09			TITLE	SCALE	
A	04.05.05			FLOAT WEB, 206L/407		
B	05.03.16			NEW ISSUE		
C	05.08.09			MOVE HOLES, ADD D3390-1 DOUB-ERS REMOVE D3390-1, NOW MACHINED		



DETAIL C  
SCALE 1:5  
RIVET HOLES NOT SHOWN  
FOR CLARITY



DETAIL D  
SCALE 1:5

RELEASED  
05-21-12

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

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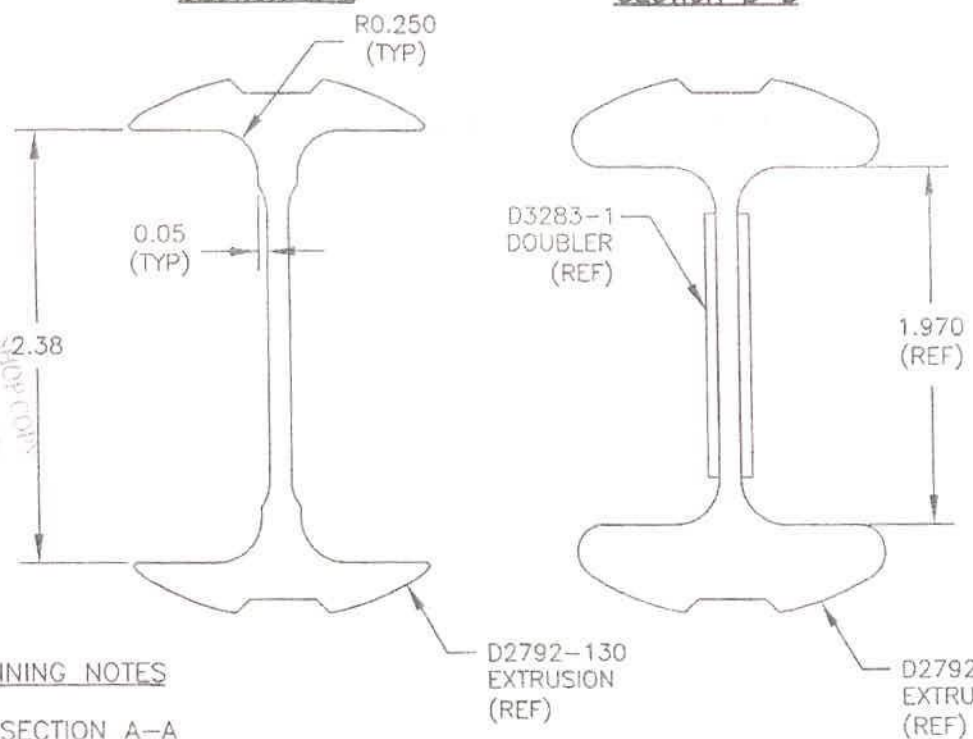


**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	TITLE	D3282	REV. C
				SHEET 2 OF 2
				SCALE
				1:20

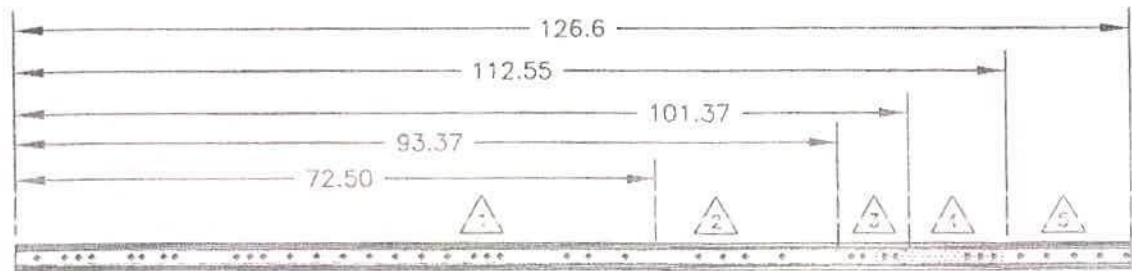
SECTION A-A

SECTION B-B



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 ( $\phi 0.128$  REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED  
05-04-12

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UNIONVILLE, PA  
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